Work Order ID 70797

Wednesday, June 15, 2011 10:57:24 AM

Item ID: D2369-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Deck Plate Locator Brackets

Start Date: 6/15/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 6/22/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** ____ **Date:** 11-06-15 **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2369 / Rev A									
100	FLOW WATER JET	0.00				B11-7-5			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2369 ☐Dwg Rev: A ☐Prog Rev: A ☐2- Deburr if necessary								
5052 . 040									(9)
110	QC2- Inspect parts off machine FAI/FAIB	0.00				B11-7-5			
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				(8)			
QC	**Memo**	0.00 6/16/06							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 70797

Wednesday, June 15, 2011 10:57:24 AM

Item ID: D2369-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Deck Plate Locator Brackets

Start Date: 6/15/2011 **Start Qty:** 6.00 **Cust Item ID:**

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 241A	0.00				11/7/11	9		
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00					11/7/11		
QC	**Memo**	0.00							
Quality Control									

MF 11-07-11

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, June 15, 2011 10:57:31 AM

Work Order ID: 70797

Parent Item: D2369-1

Parent Item Name: Deck Plate Locator Brackets

Start Date: 6/15/2011 **Required Date:** 6/22/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B now water jet 07-12-11 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	45.3000	1.354	8.551579	12		
5052-H32 .040 Sheet											B11-7-5		

Location	Loc Qty	Loc Code
MAT022	45.3	
117130	45.3	

9

117130

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70197
Description: Deck Plate Locator Bracket	Part Number:	D2369-1
Inspection Dwg: D2369 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.504	✓		V BOZ	
4.500	+/-0.010	4.501	✓		V	
1.000	+/-0.010	1.002	✓		V	
5.709	+/-0.010	5.703	✓		V	
37.996	+/-0.010	37.996	✓		T IBO1	
38.297	+/-0.010	38.287	✓		T	
5.000	+/-0.010	5.010	✓		V	
4.451	+/-0.010	4453	✓		V	
0.549	+/-0.010	.547	✓		V	
Ø0.191	+0.005/-0.000	.192	✓		V	
Ø0.128	+0.005/-0.000	.129	✓		V	
39.000	+/-0.010	39.00	✓		T	
38.544	+/-0.010	38.544	✓		T	

Measured by:	KB	Audited by:		Prototype Approval:	N/A
Date:	11-7-5	Date:	11/09/06	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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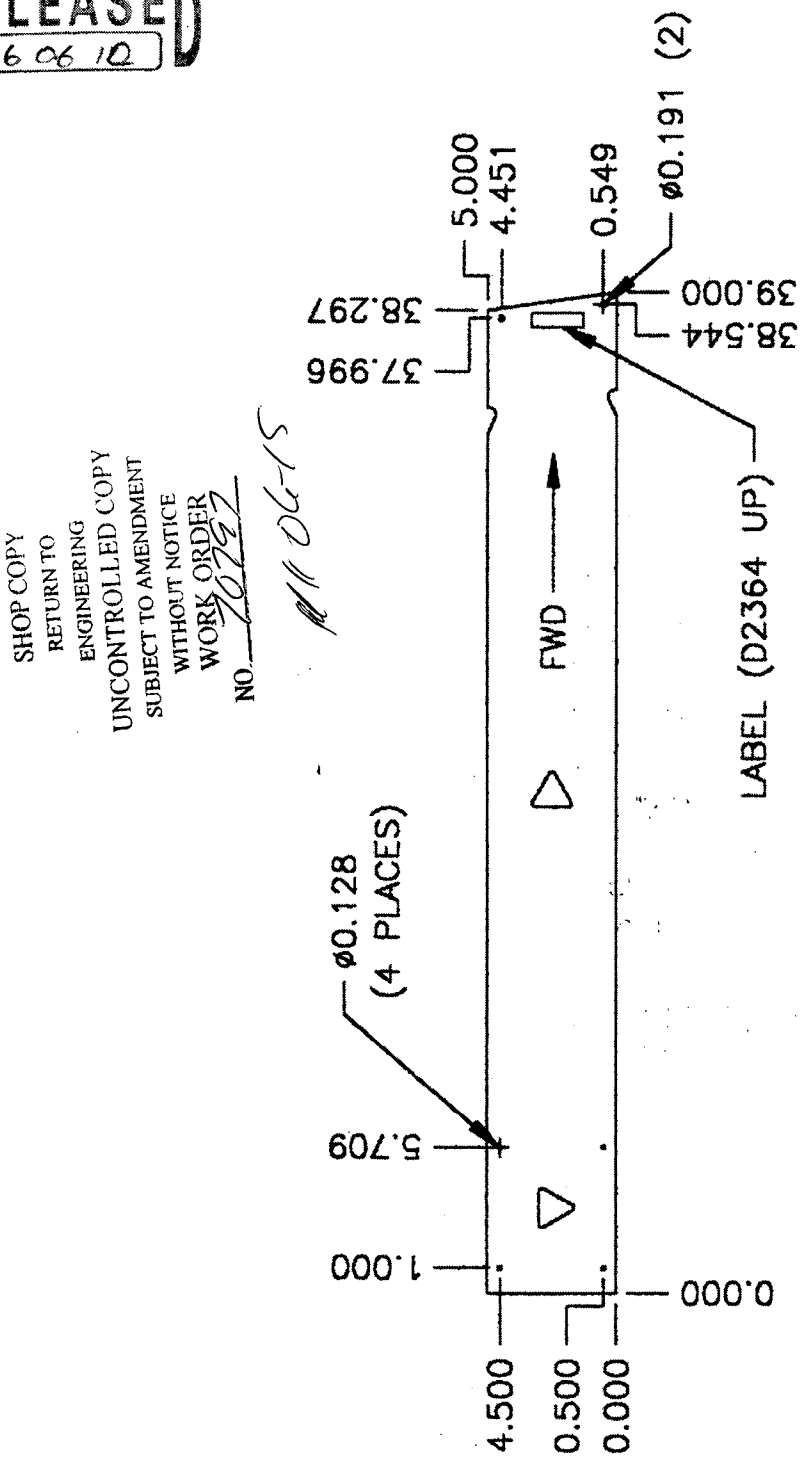
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO. / REV.
BW		D2369 / REV. A
DATE		TITLE / SCALE
95:02:20		DECK PLATE LOCATOR BRACKET / 1:7

SHEET 1 OF 2

RELEASED
96 06 10

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 10782



D2369-1

MATERIAL: 5052-H34 0.040 THICK

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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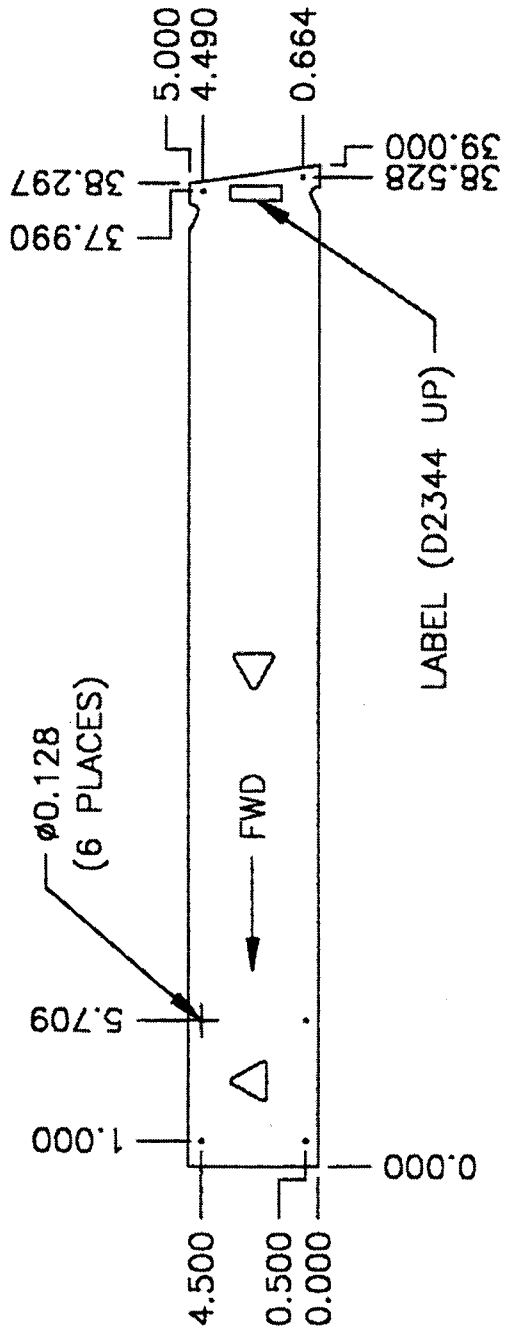
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO. D2369 — REV. A — SHEET 2 OF 2
DATE 95:02:20		TITLE DECK PLATE LOCATOR BRACKETS — SCALE 1:7

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RELEASED
96 06 10

W/O 7087



D2369-3

MATERIAL: 5052-H34 0.040 THICK

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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